

Blue

Work Order ID 53287

October 30, 2009 1:22:11 PM



Page 1

Item ID: D206-642-441

Accept



Setup Start



Revision ID: F

Stop



Item Name: Replacement Skidtube

Start Date: 29/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

09-10-30

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2650

Rev F

100

0.00



DOCUMENT CONTROL

DC

0.00

Memo

Document Control

Photocopy bluefile and create labels per PPP D206-642-441 CHG002

N/A *[Signature]*

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Start Date: 29/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-Deburr Fwd edge of tube								
	2-Remove ridge on inside of Fwd edge of tubeas per Dwg D2650								
	3-Weld Fwd Cap as per Dwg D2650. Use aluminam rod. Grind D2647 to fit as required. A/R <input type="checkbox"/> Aluminum Rod <input checked="" type="checkbox"/> <u>1112507</u> / <u>1111999</u> BE 09/10/09								
	4-Grind weld flush to cap on top surface only. BE 09/10/09								
	5-Cut aft end 138.60" from front of tube								
	6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to Ø0.312".								
	7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297".								
	8-Open using #6 Drill Bit								
	9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail								
	10-Remove inner indexing ridge on aft end of skidtubeas per Dwg D2650								
	11-Deburr and Blow out all chips form inside the tube								

1 09/11/12

1 09/11/13

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Item Name: Replacement Skidtube

Start Date: 29/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 	Skidtubes	0.00							
	Skidtubes	0.00							
	QC5								
	Memo								
	Install D2680-041 Nut plate as per Dwg								
130 	QC10- Inspect visual per QSI004- ground welds	0.00							
	QC	0.00							
	Quality Control								

z> Sorlulob3

(4)

f

z> Sorlulob3

(4)

f

— Chemical conversion

AWM 9-11-3 (1)

AWM 9-11-3

— QC3

1 M 9/11/3

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Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Skidtubes	0.00							
	Skidtubes								
	Skidtubes								
	Memo	0.00							
	1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail (without cutting fluid)								
	2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)								
	3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.								
	4-Bond D2654-7 web in place as per QSI 015Ensure holes line upAllow 12 Hrs. cure time before cutting								
	Start Date: <u>9-11-3</u> Time: <u>4:15</u>								
	Finish Date: <u>9/11/4</u> Time: <u>8:40</u>								
	A/R <u>17112391</u>								
	Sikaflex expiry date: <u>10-02-20</u>								
150	QC5- Inspect part completeness to step on W/O	0.00							
	QC	0.00							
	Quality Control								

1 - 0 AWA 9-11-3

2) Sorlulay

④

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Revision ID: F

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Item Name: Replacement Skidtube

Start Date: 29/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

160

0.00



Skid tubes

Skid tubes

Memo

0.00

1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.
A/R ☐ Aluminum Rod ☒ M112507

2-Grind welds flush as per Dwg D2650.

DP 9 - 11-4

BE 09/11/04

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650 Debur

1 M 9/11/5

165

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

3 Sorlulos

(48)

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Revision ID: F

Item Name: Replacement Skidtube

Start Date: 29/10/2009 **Start Qty:** 1.00

Required Date: 09/11/2009 **Req'd Qty:** 1.00

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start 

Stop

[illegible]

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Item ID: D206-642-441

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Setup Start



Revision ID: F

Stop



Item Name: Replacement Skidtube

Start Date: 29/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

Pressure Wash per QSI005 4.3

0.00

⇒ Ml 09/11/09



HandFinish

Memo

(+ Touchup Alodine) Ml 09/11/09

0.00

(X)

Ø

Hand Finishing

205

Spray Painting per QSI005 4.2

0.00



SprayPaint

Memo

PRIME GREY 110918
SPRAY PAINT DELFLEET BLUE 110077
CLEAR DELFLEET 113088

0.00

Ml 09 11 11 (B)

215

QC14- Inspect Spray Paint

0.00



QC

Memo

ET 09-11-12

Quality Control

0.00

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Start Date: 29/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

230

0.00



HandFinish

HandFinishing

Memo

0.00

Hand Finishing

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R ☐ Sikaflex-291 ☒ M11284

Sikaflex expiry date: ☐ 10/01

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with Sikaflex Clean excess adhesive

A/R ☐ Sikaflex-291 ☒ M11284

Sikaflex expiry date: ☐ 10/01

6-Wing Walk as per Dwg D2650-7 and QSI 005 4.4

Batch: M112623

Handwritten note: OK 09-11-16 with a circled 'D' and a large bracket pointing to the memo section.

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Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

240

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

27 S 02/11/17



f

Quality Control

250

Packaging

0.00



Packaging

Memo

0.00

PPP 53281

9/11/18 RSP

Packaging

Identify and pack for shipping as per PPP D206-642-441

Location: _____

PPP Rev: _____

260

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

09/11/19

Quality Control

u 02.11.18

Picklist Print

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Page 1

Work Order ID: 53287



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube


Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2620RevB  Skidtube, 206 Skidtube		Manufactured	No			110	Each	13.0000	1.0000			

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

13

45898

13

1 K 9/11/12

D2646RevC  Aft Cap		Manufactured	No			120	Each	44.0000	1.0000			
--	--	--------------	----	--	--	-----	------	---------	--------	--	--	--

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

44

20208

0

43801

1

46327

4

48109

39

1 BL 09/11/12

D2647RevF  Cap		Manufactured	No			140	Each	23.0000	1.0000			
--	--	--------------	----	--	--	-----	------	---------	--------	--	--	--

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

23

10773

7

43846

16

1 AC 09/11/12

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Work Order ID: 53287



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2654-7RevE1		Manufactured	No			160	Each	2.0000	1.0000			
Web												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FG

2

52801

2

CCR264SS3-3

Purchased

No

170

Each

65.0000

2.0000



Cherry Rivet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

65

111548

38

111827

1

112314

26

B-52917 AWM 9-11-03 (*)

2 14 9/11/15

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Work Order ID: 53287



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2649RevB1		Manufactured	No			170	Each	476.0000	23.0000			
Cross Bolt Spacer												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
LG	83	
51529	83	
Main Warehouse		
ST	393	
36013	5	
47112	382	
48271	6	

23 BE 09/11/09

D2680-041RevB1

Manufactured No

170

Each

75.0000

1.0000



Nut Plate

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	75	
33061	10	
44086	65	

1 n 9/11/15

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Work Order ID: 53287



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

ALS4-1032-130

Purchased

No

230

Each

5,073.000

60.0000



Insert

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

5073

110511 ✓

5073

AN960JDTOL AN960C12

Purchased

No

230

Each

5,735.000

62.0000



Washer

9/11/12

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

5735

101291

16

104885

153

105793

236

AN960JDIOL

109632 ✓

420



110985

4910

60 Bl 09-11-16 .

RO

2 Bl 09-11-16 .

W/O: 53287		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09.11.12	230	Qty (60) AN960 JD10L REPLACED WITH Qty (60) AN960 C10L M 112612	BR	09-11-16	60	 09.11.19 per QSI/142	 09/11/19

Part No: D206-642-441 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 53287



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN960JD416 Purchased No 230 Each 4,591.000 1.0000



Washer

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 4591

108161 519

110523 340

111279 101

111916 482

112314 ✓ 3149

16941 0

CR3212-4-03 Purchased No 230 Each 292.0000 2.0000



Cherry Rivet

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 292

111359 92

112314 200

1 BR 09-11-16

2 M 9/11/5

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Work Order ID: 53287



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2651-1RevB		Manufactured	No			230	Each	359.0000	22.0000			
Plug												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST 53349	359	
43990	81	
45490	28	
51530	250	

22 1009-11-16

D2651-3RevB		Manufactured	No			230	Each	991.0000	22.0000			
O-Ring												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	991	
43849	3	
46114 ✓	988	

22 09-11-16

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Work Order ID: 53287



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3535-15RevB		Manufactured	No			230	Each	22.0000	1.0000			
Wearshoe												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

<u>Location</u>

Main Warehouse

FP

17

51671 ✓

17

Main Warehouse

ST

5

30750

4

42233

1

D3535-23RevB

Manufactured

No

230

Each

15.0000

1.0000



Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

<u>Location</u>

Main Warehouse

FP

13

51618 ✓

13

Main Warehouse

ST

2

48156

2

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Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3535-37RevB		Manufactured	No			230	Each	18.0000	1.0000			
Wearshoe												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	13	
51654 ✓	13	
Main Warehouse		
ST	5	
47374	5	

1 BL 09-11-16

D3536-15RevA		Manufactured	No			230	Each	32.0000	1.0000			
Gasket												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	32	
48159	6	
51600 ✓	26	

1 BL 09-11-16

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Parent Item: D206-642-441RevF

Parent Item Name: Replacement Skidtube


Comments:

Start Date: 29/10/2009

Required Date: 09/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3536-23RevA		Manufactured	No			230	Each	21.0000	1.0000			
												
Gasket												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

12

51609 ✓

12

Main Warehouse

ST

9

30754

1

47713

8

D3536-37RevA

Manufactured

No

230

Each

20.0000

1.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

20

47375 ✓

7

51641

13

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Work Order ID: 53287

Parent Item: D206-642-441RevF

Parent Item Name: Replacement Skidtube



Comments:

Start Date: 29/10/2009

Required Date: 09/11/2009



Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3537-1RevC		Manufactured	No			230	Each	299.0000	6.0000			
												
Wearpad												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	2	
48288	2	
Main Warehouse		
FP17	297	
51624	30	
51678 ✓	162	
51679	105	

6 Bk 02-11-16

D3537-3RevC		Manufactured	No			230	Each	60.0000	1.0000			
												
Wearpad												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	60	
30758	7	
33881 ✓	17	
35697	36	

1 Bk 02-11-16

Picklist Print

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Work Order ID: 53287

Parent Item: D206-642-441RevF

Parent Item Name: Replacement Skidtube


Comments:

Start Date: 29/10/2009

Required Date: 09/11/2009


Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS27039-1-08		Purchased	No			230	Each	2,947.000	2.0000			
												
Screw												


<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2947	
110467 ✓	188	
110552	759	
110835	2000	

2 09-11-16

MS27039-4-06		Purchased	No			230	Each	75.0000	1.0000			
												
Screw												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	75	
109061 ✓	75	

1 09-11-16

MS27039C1-08		Purchased	No			230	Each	962.0000	60.0000			
												
SCREW												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	962	
19185 ✓	962	

60 09-11-16

October 30, 2009 1:22:16 PM

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QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

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NOTES:

MATERIAL: N/A
FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4

TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

UNITS: INCHES UNLESS OTHERWISE NOTED

BREAK SHARP EDGES: 0.005 TO 0.010 MAX

IDENTIFICATION: NONE

WEIGHT: N/A

WELD PER DART QSI 004

DAMAGE TOLERANCE ON FWD BEND:





THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.

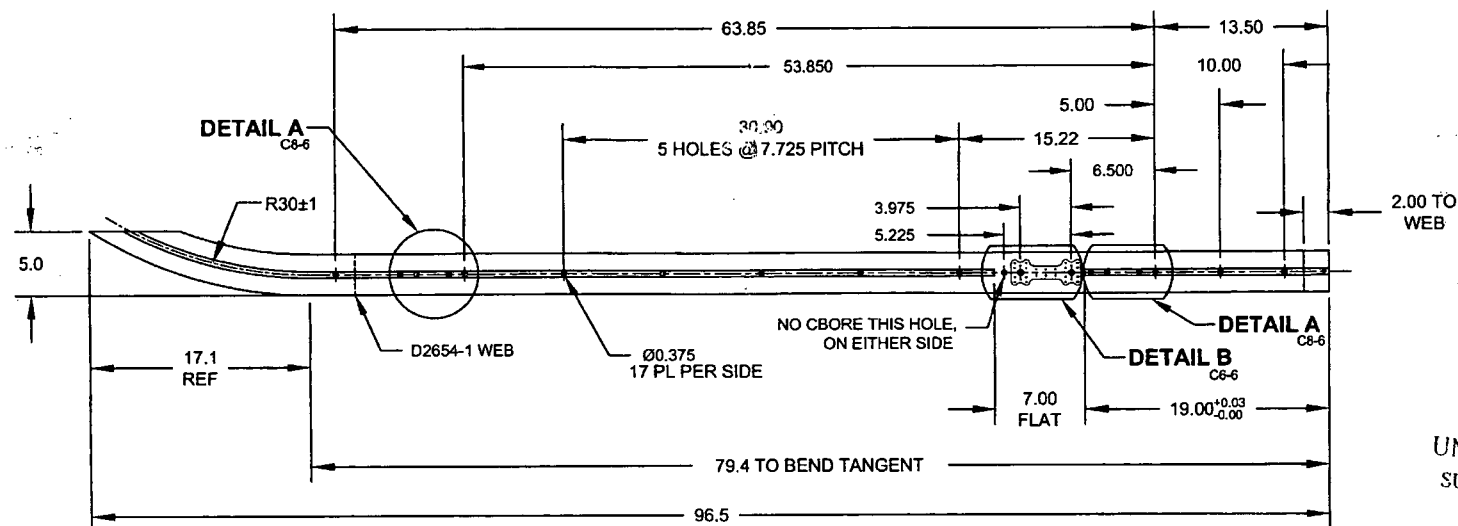
) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015

) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.

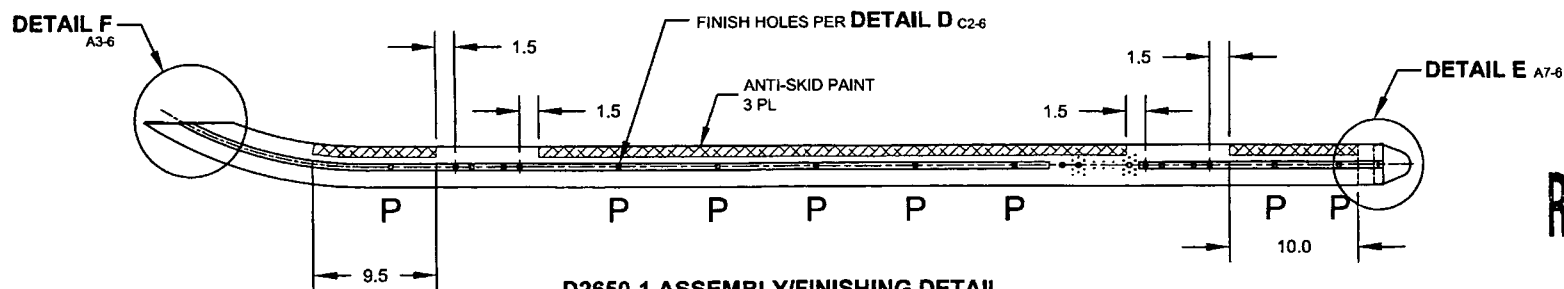
) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	RMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW; INCCRP. DE091369153/9163 MOD GROUND HANDLING ON D2650-1/3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC	
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CHECKED		DRAWING NO.	REV. F
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D2650-1 BENDING/DRILLING DETAIL

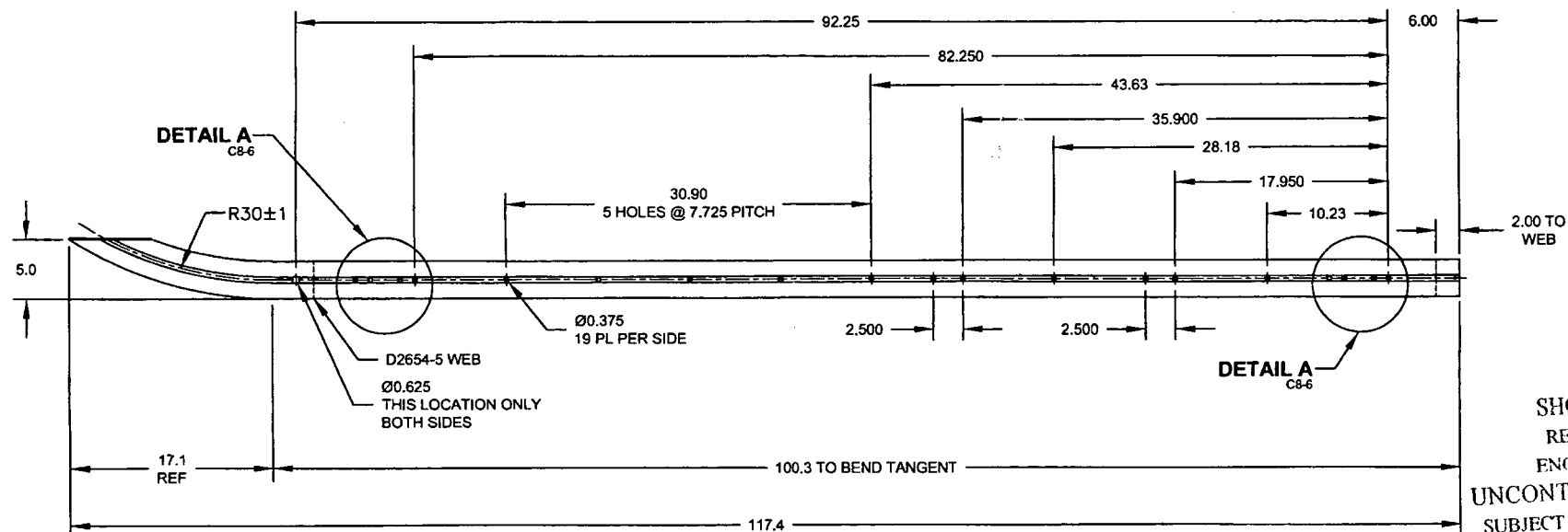
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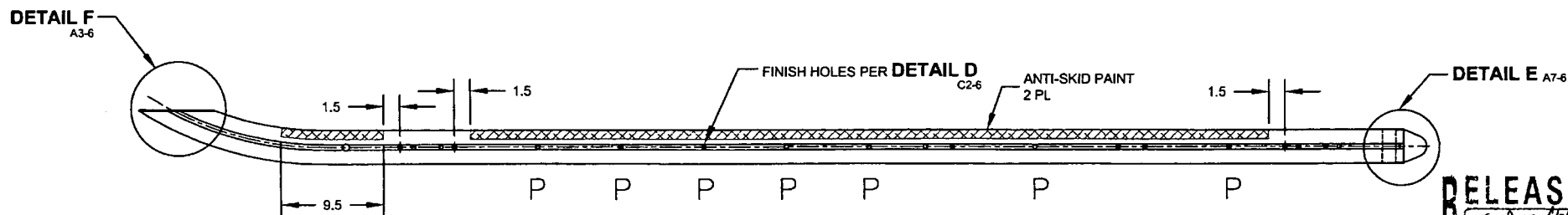
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D2650-5 BENDING/DRILLING DETAIL

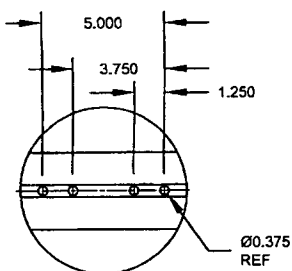
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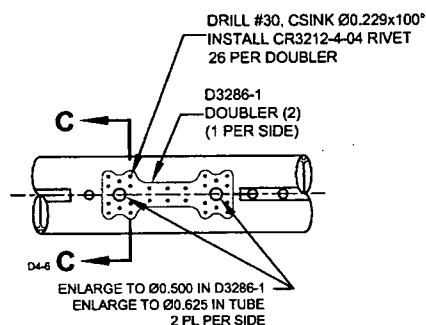
D2650-5 ASSEMBLY/FINISHING DETAIL

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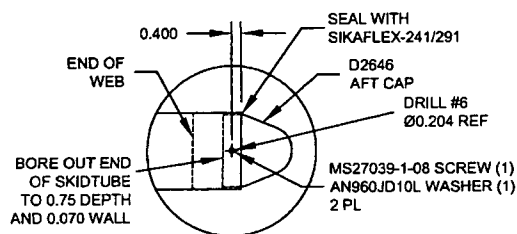
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DETAIL A
SCALE 2X
C2-2
D7-2
C2-3
D7-3
C2-4
D7-4
C2-5
D6-5

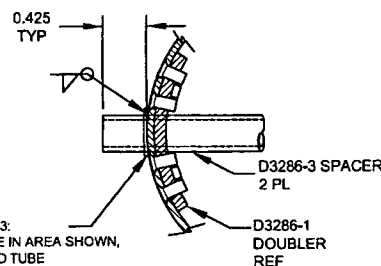


DETAIL B
SCALE 2X
C3-2
C3-3

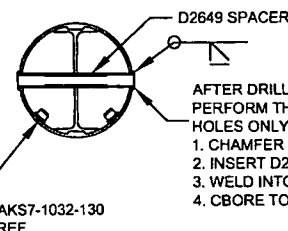


DETAIL E
SCALE 2X
B2-2
B2-3
B1-4
B1-5

SECTION C-C C7-6
SCALE NONE



- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.030x45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE.



DETAIL D
FOR Ø0.375 HOLES ONLY
SCALE 3X
B4-2
B4-3
B4-4
B4-5

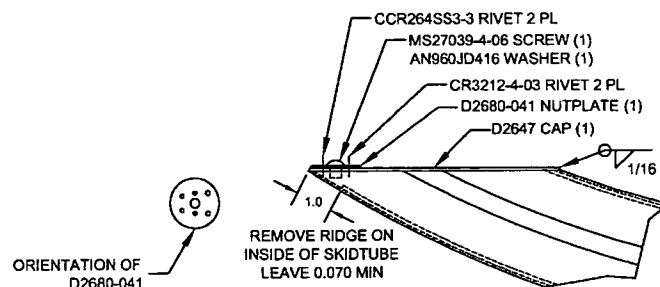
- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. CBORE TO Ø0.313 X 0.75 DP

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DETAIL F NOTES:





1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH



DETAIL F
SCALE NONE
B8-2
B8-3
B8-4
B8-5

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NO. 214

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 52855
Part number: D206-K42-251
Description: 206 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pat Dunlop Date of Test Coupon 09.10.29
Welder Barclay Elliott Date of Test Coupon 09.10.29

The above named individual is qualified in accordance with AWS D17.1.2001 to weld